

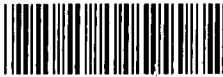
Date: Wednesday, 6/27/2007 1:07:14 PM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|--|------------------|----------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : STEP STRUT |
| Job Number | : 33205 | | |
| Estimate Number | : 11938 | | |
| P.O. Number | : N/A | Part Number | : D2017123 |
| This Issue | : 6/27/2007 | S.O. No. | : N/A |
| Prsht Rev. | : NC | Drawing Number | : D2017 REV E1 |
| First Issue | : N/A | Project Number | : N/A |
| Previous Run | : N/A | Drawing Revision | : E1 |
| | | Material | : N/A |
| Written By | : <u>JA 07.06.28</u> | Due Date | : 7/10/2007 |
| Checked & Approved By | : <u>JA 07.06.28</u> | Qty: | 6 Um: Each |
| Comment | : Est D 02.06.19 Update processes (Ref. ECN 435) KJ/RF | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|--------------|
| Seq. #: | Machine Or Operation: | Description: |
|---------|-----------------------|--------------|

| | | |
|-----|----------------|--------------------------|
| 1.0 | M304TR0750W049 | 304 RD Tube .750 x .049W |
|-----|----------------|--------------------------|



Comment: Qty.: 1.1550 f(s)/Unit Total: 6.9300 f(s)

Punch tube type 304-2B, 3/4" Ø. X .049" wall to length per Dwg. D2017 & spec control D2638

Batch No. M104862

Deburr

RF 07-07-06 6

SAD 07/07/09 (6)

| | | |
|-----|-----|------------------------------|
| 2.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/09 (6)

| | | |
|-----|----------------|----------------|
| 3.0 | POWDER COATING | POWDER COATING |
|-----|----------------|----------------|



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

BR 07-07-10 (6)

| | | |
|-----|-----|---|
| 4.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
|-----|-----|---|



Comment: INSPECT POWDER COAT

CR 07/11 (6)

| | | |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5205/ CR 07/16 (6)

4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/07/23
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 6/27/2007 1:07:14 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP STRUT

Job Number: 33205

Part Number: D2017123

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



07.07.16 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 07.07.16

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

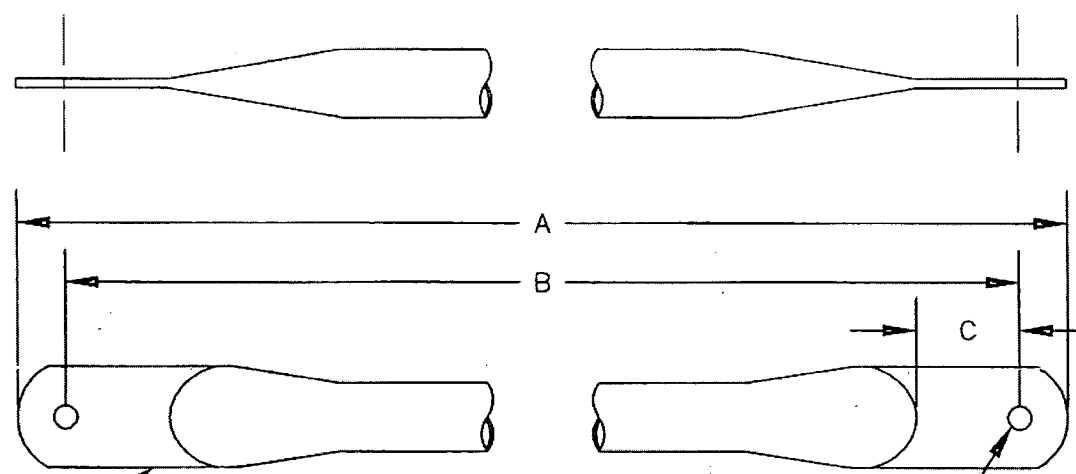
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



RELEASED
99.05.11 KE

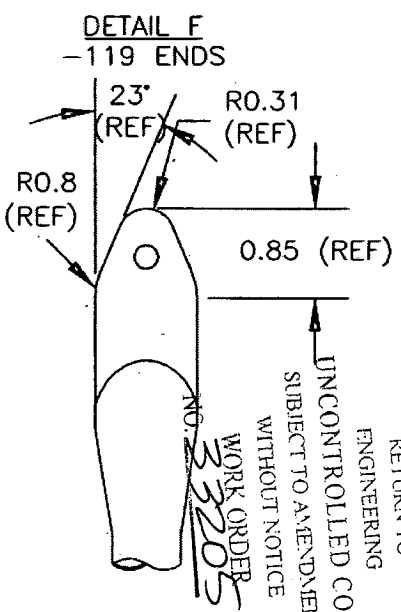
| DESIGN | DRAWN BY | DART AEROSPACE LTD |
|----------|-------------|---|
| BW | RF | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO. |
| KE | RF | D2017 |
| DATE | TITLE | SHEET 1 OF 2 |
| 99.04.16 | STEP STRUTS | SCALE |
| | | NIS |
| C | 95.01.26 | ADDED PARTS |
| D | 96.03.28 | ADD PARTS |
| E | 99.04.16 | ENDS PUNCHED PER SPEC CTRL; -119 CHANGE (TSR A897) |
| E1 | 07.05.22 | ADD FINISH |



PUNCH ENDS PER
SPEC CTRL D2638
(-119 SEE NOTE)

"D" DIA 0.25 TO BE PUNCHED (TYP. BOTH ENDS)
"E" DIA TO BE OPENED MANUALLY (ONE END ONLY)

| Part Number | A | B | C | D | E |
|-------------|-------|-------|------|-------|-------|
| D2017-101 | 17.73 | 16.93 | 1.30 | 0.250 | 0.312 |
| D2017-103 | 18.74 | 17.94 | 1.30 | 0.250 | 0.312 |
| D2017-105 | 14.95 | 14.15 | 1.30 | 0.250 | - |
| D2017-107 | 15.61 | 14.81 | 1.30 | 0.250 | - |
| D2017-109 | 13.93 | 13.13 | 1.30 | 0.250 | - |
| D2017-111 | 15.30 | 14.50 | 1.30 | 0.250 | - |
| D2017-113 | 20.50 | 19.70 | 1.30 | 0.250 | 0.312 |
| D2017-115 | 12.42 | 11.62 | 1.30 | 0.250 | - |
| D2017-117 | 13.86 | 13.06 | 1.30 | 0.250 | - |
| D2017-119 | 26.75 | 25.95 | 1.30 | 0.250 | - |
| D2017-121 | 12.30 | 11.50 | 1.30 | 0.250 | - |
| D2017-123 | 12.92 | 12.12 | 1.30 | 0.250 | - |
| D2017-125 | 19.55 | 18.75 | 1.30 | 0.250 | - |
| D2017-127 | 20.30 | 19.50 | 1.30 | 0.250 | - |
| D2017-129 | 31.43 | 30.63 | 1.30 | 0.250 | - |
| D2017-131 | 19.68 | 18.88 | 1.30 | 0.250 | - |
| D2017-133 | 30.66 | 29.86 | 1.13 | 0.250 | - |



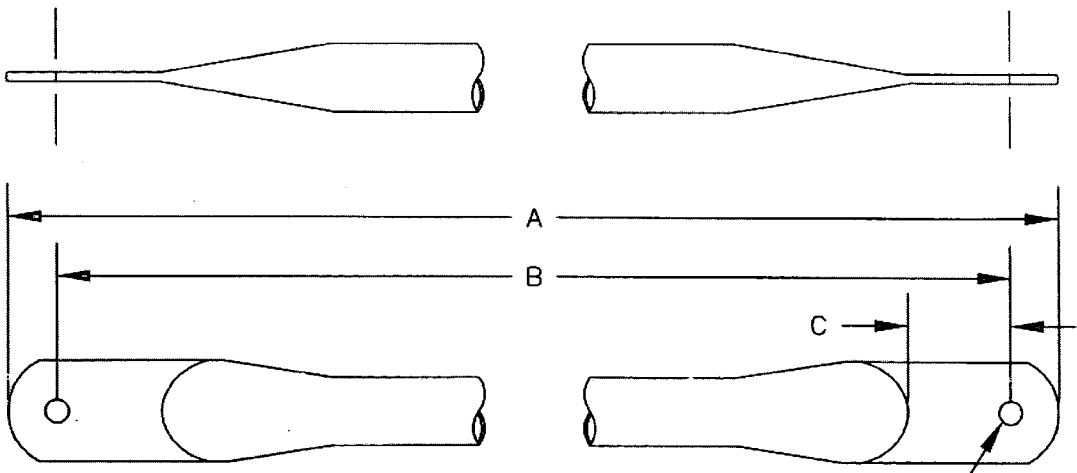
NOTE:
FOR D2017-119: PUNCH PER D2638, GRIND ENDS PER DT8360 (SEE DETAIL F FOR REF.)
BEND FLARED ENDS 8° UP/ 8° DOWN
MATERIAL: 304/316/318 SS, 0.75 OD x 0.049 WALL, ENSURE SEAMLESS TUBING IS USED
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 / E1



| | | | |
|------------------|----------------------|---|--------|
| DESIGN BW | DRAWN BY RT | DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA | |
| CHECKED KE | APPROVED RT | DRAWING NO. D2017 | REV. E |
| DATE 99.04.16 | TITLE STEP STRUTS | SHEET 2 OF 2 | |
| | | SCALE NTS | |

RELEASED
99.05.11 KE



"D" DIA 0.25 TO BE PUNCHED (TYP. BOTH ENDS)

| Part Number | A | B | C | D |
|-------------|-------|-------|------|-------|
| D2017-201 | 21.31 | 20.51 | 1.30 | 0.250 |
| D2017-203 | 16.39 | 15.59 | 1.30 | 0.250 |
| D2017-205 | 16.53 | 15.73 | 1.30 | 0.250 |
| D2017-207 | 13.85 | 13.05 | 1.30 | 0.250 |
| D2017-209 | 15.64 | 15.33 | 1.30 | 0.250 |
| D2017-211 | 15.67 | 14.87 | 1.30 | 0.250 |
| D2017-213 | 15.82 | 15.02 | 1.30 | 0.250 |
| D2017-215 | 16.47 | 15.67 | 1.30 | 0.250 |
| D2017-217 | 16.70 | 15.90 | 1.30 | 0.250 |
| D2017-219 | 13.65 | 12.85 | 1.30 | 0.250 |
| D2017-221 | 13.58 | 12.78 | 1.30 | 0.250 |
| D2017-223 | 12.95 | 12.15 | 1.30 | 0.250 |
| D2017-225 | 13.99 | 13.19 | 1.30 | 0.250 |
| D2017-227 | 30.67 | 29.87 | 1.30 | 0.250 |
| | | | | |
| | | | | |
| | | | | |

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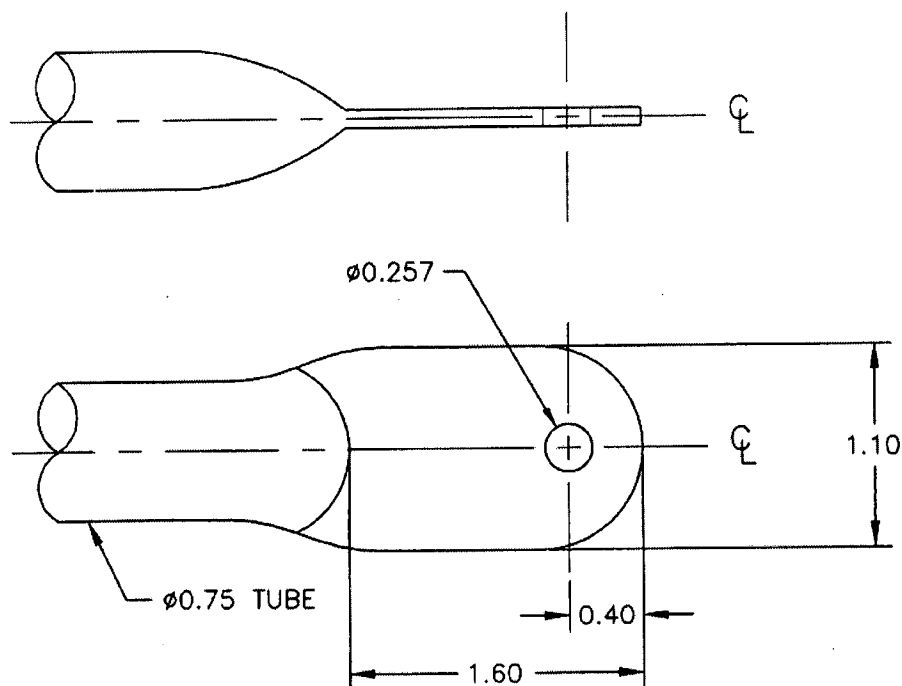
NOTE:
MATERIAL: 304/316/318 SS, 0.75 OD x 0.049 WALL, ENSURE SEAMLESS TUBING IS USED
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3/ET



| | | | |
|------------------|------------------------------------|---|------------------------|
| DESIGN KE | DRAWN BY KE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED MAY | APPROVED [Signature] | DRAWING NO. D2638 | REV. A SHEET 1 OF 1 |
| DATE 98.04.28 | TITLE PUNCH DT8117 SPEC CONTROL | | SCALE 1:1 |
| A | 98.04.28 | NEW ISSUE | |

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98/05/05 KE

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117



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